

Date: Wednesday, 6/14/2006 1:45:08 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 27544	
Estimate Number : 10310	
P.O. Number : N/A	Part Number : D26175
This Issue : 6/14/2006 S.O. No. : N/A	Drawing Number : D2617 REV D2
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : D2
Previous Run : 24942	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 6/16/2006 Qty: 30 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est H 04.07.14 Reformat; added step 5 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0500W058	6061-T6 Tube .500 x.058W
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Comment: Qty.: 0.0205 f(s)/Unit Total : 0.6143 f(s)
 6061-T6 Round Bar 1.5"
 Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6)
 Ø0.500" tubing x 0.058" wall
 M6061T6T0.500W.058)
 Batch M19405

[Signature] 06/06/14

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Machine as per Folio FA438 and Dwg D2617

2-Deburr

N/A Machined Manually

[Signature] 06/06/14 30

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature] 06/06/14 30

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.G 06/06/14 30

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 06 06 15 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *P* Date: 26/06/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BUSHING

Job Number: 27544

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

DC 06/06/15 (30)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5153

FC 06 06 15 (30)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DC 06/06/16 (30)

Job Completion



LC 06-06-15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

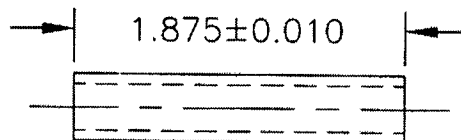
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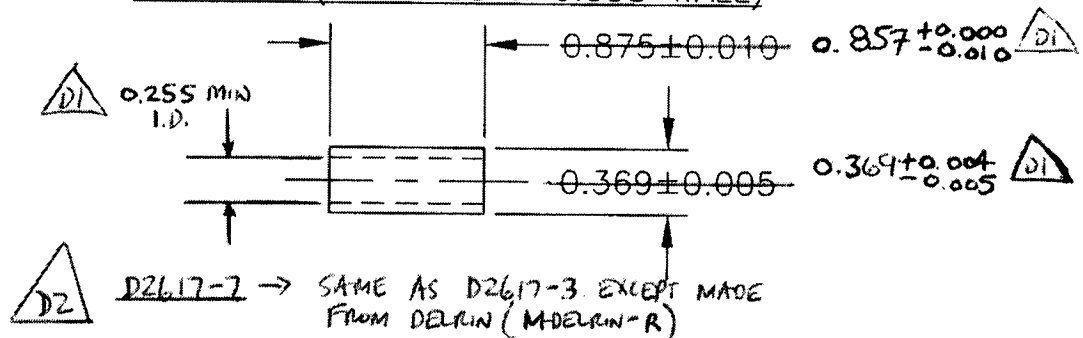


DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2617	REV. D SHEET 1 OF 1
DATE 01.07.04				TITLE BUSHING	SCALE 1:1
DL 04.09.10 #1P		ADD D2617-7			
A		96.10.08	NEW ISSUE		
B		97.05.08	.875 WAS 1.125		
C		97.06.04	0.369 DIA WAS 0.375		
D		01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE		
D1	CP	04.07.12	CORRECT TOLERANCE (NCR 779)		

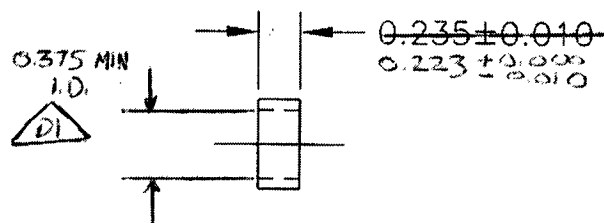
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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